Dart Aerospace Ltd.

Date: Thursday, 10/08/2006 10:01:51 AM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 28131
Estimate Number : 11921
P.O. Number : N/A
This Issue : 10/08/2006 **S.O. No.** : N/A
Prsht Rev. : NC
First Issue : N/A **Type** : SMALL /MED FAB
Previous Run :
Written By :
Checked & Approved By :
Comment : Est. C 02.03.05 Re-format NG

Drawing Name : TUBE ASSEMBLY
Part Number : D2003045
Drawing Number : D2003 REV B
Project Number : N/A
Drawing Revision : B
Material : N/A
Due Date : 05/09/2006 **Qty:** 5 **Um:** Each

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	M304TR0500W035	304 RD Tube .500 x .035W

Comment: Qty.: 0.2625 f(s)/Unit Total : 1.3125 f(s)
304 RD Tube .500 x .035W
Cut as per template D2003-045 (2.44" long)
Material:1/2"Æ x 0.035" wall AISI 304 SS tubing Batch: M101593
Cut: 3.50" long as per Dwg D2003
Material: M2650-14 Heat sleeve
Batch: M17071

FF 06.08.14 5

2.0	MS208198J	Sleeve

Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)
Pick
Qty Part Number Desc Batch:
2 MS20819-8J Sleeve M101189

FF 06.08.14 5

3.0	AN8188J	Nut

Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)
Pick
Qty Part Number Desc Batch:
2 AN818-8J Nut M101189

FF 06.08.14 5

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes (No) **DQA:** ~~ND~~ **Date:** 6/08/17

QA: N/C Closed: _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Date: Thursday, 10/08/2006 10:01:52 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** TUBE ASSEMBLY

Job Number: 28131 **Part Number:** D2003045

Job Number:

Seq. #:	Machine Or Operation:	Description :
4.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1
Form tube as per template D2003-045
Assemble as per Dwg D2003

FF 06.08.14 5

5.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP

06.08.15 (5)

6.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: ST13

AR 06/08/16 (5)

7.0	DC	DOCUMENT CONTROL

Comment: DOCUMENT CONTROL
Inspection Level 21

(5)
06/08/17

Job Completion

C 06/08/17

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

QA: N/C Closed: _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2003	REV. B SHEET 1 OF 2
DATE 99.06.08		TITLE 206 CABIN HEATER TUBE ASSEMBLIES	SCALE NTS

A	90.04.09	NEW ISSUE
B	99.06.08	UPDATE PER TEMPLATES; ADD P/N'S; 0.025 TUBING NOW 0.035 (TSR1049)

RELEASED
99.06.08 KE

P/N	TEMPLATE	HEATSLEEVE LENGTH[1]	CUT LENGTH OF TUBE[2]	MS20819-8J SLEEVE	AN818-8J NUT	MS20819-8D SLEEVE	AN818-8D NUT	MS20819-6D SLEEVE	AN818-6D NUT	DESC.	MATERIAL[4/5/7]	VENDOR OR SPEC
D2003-001	T2003-001	5.2	6.00					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-003	T2003-003	7.3	8.12					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-005	T2003-005	9.8	10.62					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-007	T2003-007	20.0	19.63					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-009	T2003-009	12.38	12.44					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-011	T2003-011	33.31	32.38					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-013	T2003-013	12.7	13.54					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-015	T2003-015	17.2	18.00					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-017	T2003-017	17.0	16.25					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-019	T2003-019	9.8	10.62			2	2			TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-700/6
D2003-021	T2003-021	N/A	2.25			2	2			TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-700/6
D2003-023	T2003-023	4.5	5.33			2	2			TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-700/6
D2003-025	T2003-025	9.8	10.60			2	2			TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-700/6
D2003-027	T2003-027	7.25	7.38			2	2			TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-700/6
D2003-029	T2003-029	17.2	18.00			2	2			TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-700/6
D2003-031	T2003-031	14.6	15.38	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-033	T2003-033	29.75	29.62	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-035	T2003-035	24.7	27.00	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-037	T2003-037	24.81	23.38	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-039	T2003-039	34.0	34.00	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-041	T2003-041	6.0	5.88	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-043	T2003-043	11.7	10.75	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-045	T2003-045	3.50	2.44	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-047	T2003-047	5.56	5.56	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-049	T2003-049	33.2	34.00	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-077	T2003-077	N/A	6.25					1	1	JET	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-101	T2003-101	13.25	13.13					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-600/6
D2003-103	T2003-103	12.38	12.00					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-600/6
D2003-105	T2003-105	10.75	10.60					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-600/6
D2003-107	T2003-107	12.75	12.25					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-600/6
D2003-109	T2003-109	8.25	8.125			2	2			TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-600/6
D2003-111	T2003-111	4.75	4.625			2	2			TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-600/6
D2003-116	T2003-116	4.0								HEATSLEEVE	M2650-20 CRINKLE-SOFT	STRATOFLEX
D2003-120	T2003-120	4.0								HEATSLEEVE	M2650-16 CRINKLE-SOFT	STRATOFLEX
D2003-14	T2003-14	4.0								HEATSLEEVE	M2650-14 CRINKLE-SOFT	STRATOFLEX
D2003-16	T2003-16	4.0								HEATSLEEVE	M2650-16 CRINKLE-SOFT	STRATOFLEX
D2003-205	T2003-205	9.75	9.60					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-207	T2003-207	3.75	3.75					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2003	REV. B SHEET 2 OF 2
DATE 99.06.08		TITLE 206 CABIN HEATER TUBE ASSEMBLIES	SCALE NTS

OA COPY ISSUED

RELEASED
99.06.09 KE

Notes:

(1) USE STRATOFLEX M2650-6 CRINKLE-SOFT HEATSLEEVE.

(2) TUBING ASSEMBLIES TO BE CUT AND BENT IN ACCORDANCE WITH TEMPLATES.

(3) TUBES TO BE FLARED 30° TO MATE WITH FITTINGS MADE TO MS33514.

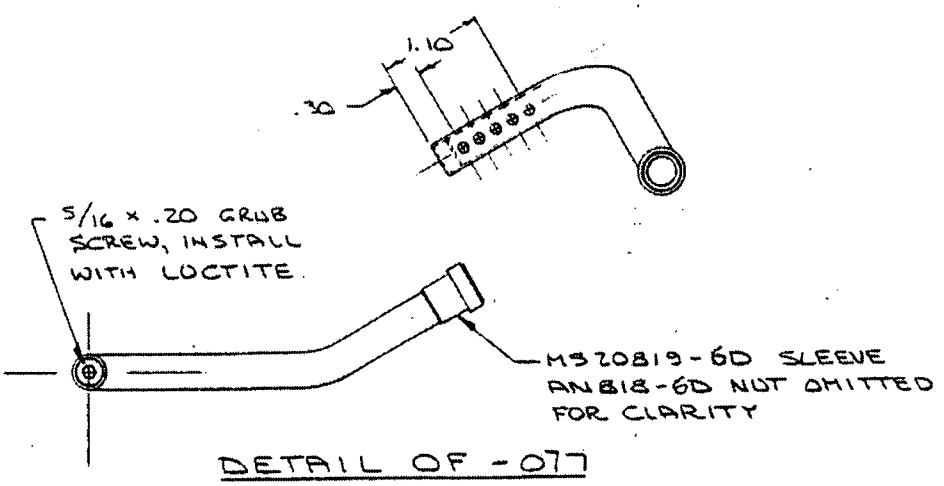
(4) ENSURE SEAMLESS TUBING IS USED.

(5) INSTALL HEATSLEEVE OVER ALL TUBES WITH A DESIGNATED LENGTH OF HEATSLEEVE PER THE PARTS LIST.

(6) 5052 (WW-T-700/4) TUBING MAY BE SUBSTITUTED WHEN 6061 TUBING IS NOT AVAILABLE.

(7) 0.049 WALL THICKNESS CRES TUBING MAY BE SUBSTITUTED WHEN 0.035 IS NOT AVAILABLE.

(8) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.



DETAIL OF -077